



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBST2812-P-11
Job Sheet 182152



DL-5 #25

9-20

Part No: RBST2812-P-11

Job Qty: 6 ea

Part Name: Dual Seat

DAS
21
9-89



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/19/18

Job Tracking No:

Due Date: 8/30/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBST2800-P Rev. 1 IPP Rev. A 18.06.21 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/30/18	8/30/18	0.00	0.00	Start Up Machining-2		
110	Mori Seiki	6 pcs	8/30/18	8/30/18	0.00	1.50	MORI SL-154		
120	QC	6 pcs	8/30/18	8/30/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs	8/30/18	8/30/18	0.00	0.00	QC8 Machining-4		
150	Outsource	6 pcs	8/30/18	8/30/18	0.00	0.00	Outsource12		
160	Packaging	6 pcs	8/30/18	8/30/18	0.00	0.00	Packaging2		
170	QC	6 pcs	8/30/18	8/30/18	0.00	0.00	QC6		
180	Packaging	6 pcs	8/30/18	8/30/18	0.00	0.00	Packaging3-1		
190	QC21-SA	6 Ea	8/30/18	8/30/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FC 341 FOLIO REV: 9-89 DWG REV: 2-Deburr
 Descriptions: 150 - -Issue P/O to GROUPE ALTECH; PO 211547 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R1.375	4140 Round Bar 1.375	.4380 ft (.073 ea)	90-Start up Operation	5049431

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140H-R1.375	0	11	0

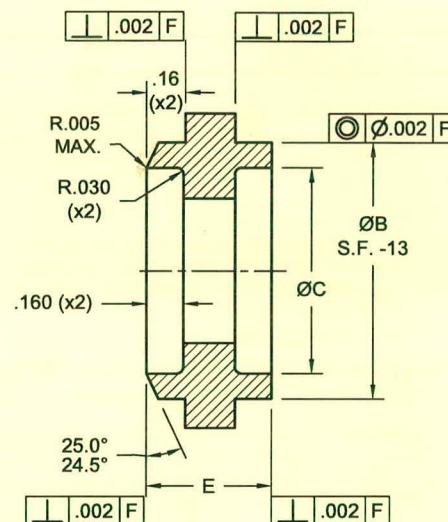
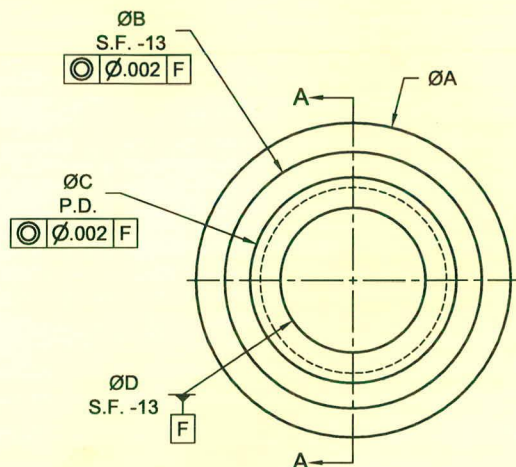
Part Specifications

Specifications could not be found.

Plex 9/6/18 8:49 AM dart.logan.david

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D -11 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES.	7/26/12	RJC



SECTION A-A

-11

DUAL SEAT

TOOL #	ØA +.010 -.020	ØB +.000 -.003	ØC +.002 -.000	ØD +.005 -.003	E +.010 -.010	MATERIAL
RBST3008P	1.375	1.122	.837	.632	.710	4140 Q&T RND. BAR Ø1-3/8 x 7/8

RED BARN MACHINE	
TITLE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. TOOL#(see chart)-11 DUAL SEAT	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-09
DRAWN BY: PERRITT APPROVED: <i>D Wed</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON BEARING SEE CHART	
SHEET 7 of 9	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order:		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				
Date : _____	Step #: _____	QTY Effective : _____				MRB (QSI042) Approval			
Description Work Order Deviation			Disposition			Completed By			
<i>[Handwritten: 10/29/18]</i>						Lead hand / Supervisor Approval Verification			
						QC / QA Coordinator Approval			
OTHER: _____			FAULT CATEGORY						
			☐ Power Loss/Surge			☐ Positioned Wrong			
			☐ Folio/Program			☐ Outside Dimensions			
			☐ Grain			☐ Over/Under tolerance			
			☐ Weld			☐ Part Incorrect			
			☐ Wrong Stock Pulled			☐ Part Lost/Missing			
			☐ Out of Sequence			☐ Part Moved			
			☐ Off-set			☐ Drawing			
			☐ Mislabeled			☐ Finish			
			☐ Fit/Function			☐ Misread			
			☐ Misaligned/off center			☐ Turning Sequence			

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 832-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S122412



Part: RBST2812 - P - 11

Job No: 182152

Serial No/Batch: S122412

Revision: 1

Inspector: _____

Exp Date: _____

Instructions: _____

Date: 10/29/18



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

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PURCHASE ORDER **PO041549**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041549
PO Date: 11/1/18
Due Date: 11/11/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments: Please confirm delivery date upon pricing

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182153	RBST2812-P-13	Receiver -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/9/18	10 pcs	0 pcs	10 pcs	\$0.866/pcs	\$8.66

10 X NOV 10 2018

Line Item Note ** Need by Nov. 9, confirm if possible



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PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	182157	RBST2812-P-7	Cap -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/8/18	10 pcs	0 pcs	10 pcs	\$0.866/pcs	\$8.66

10 X NOV 10 2018

Line Item Note ** Need by Nov. 9, confirm if possible

3	178485	RBT18560-3	Ring -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/9/18	7 pcs	0 pcs	7 pcs	\$1.35/pcs	\$9.45
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7X NOV 10 2018



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PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	184265	RBE117-12020W17	Mount -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1144 Stress Proof -Certificate of Conformity is required	Firmed	-	11/9/18	8 pcs	0 pcs	8 pcs	\$3.20/pcs	\$25.60
5	185110	RBE117-12020W18	Pusher -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1144 Stress Proof -Certificate of Conformity is required	Firmed	-	11/9/18	4 pcs	0 pcs	4 pcs	\$3.45/pcs	\$13.80

8 X

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[Signature]

4 X

NOV 10 2018

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PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	184470	RBT18700A-2	Bolt Modified -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	11/9/18	12 pcs	0 pcs	12 pcs	\$0.866/pcs	\$10.39
7	182152	RBST2812-P-11	Dual Seat -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/9/18	11 pcs	0 pcs	11 pcs	\$1.35/pcs	\$14.85

12x NOV 10 2018

11x NOV 12 2018

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Line Item Note **Need for Nov. 11, confirm if doable**



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PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	182158	RBST2812-P-9	Stud -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/9/18	10 pcs	0 pcs	10 pcs	\$0.866/pcs	\$8.66

10 X NOV 10 2018

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Line Item Note **Need for Nov. 11, confirm if doable**

9	182154	RBST2812-P-15	Tensioner -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/9/18	10 pcs	0 pcs	10 pcs	\$0.867/pcs	\$8.67
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10 X NOV 12 2018

[Signature]

Line Item Note **Need for Nov. 11, confirm if doable**



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PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
10	177797	RBEM652V3002101-M-27	Stud -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/9/18	13 pcs	0 pcs	13 pcs	\$0.866/pcs	\$11.26

13x NOV 10 2018

Line Item Note **Need for Nov. 11, confirm if doable**

Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/5/18 10:32 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014102-1)

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 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014102- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
09-Nov-2018		Aman		041549				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBST2812-P-13 Rev. ✓	RBST2812-P-13 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0
2	RBST2812-P-7 Rev. ✓	RBST2812-P-7 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0
3	RBT18560-3 Rev. ✓	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7 ✓	0	0	0
4	RBE117-12020W17 Rev. ✓	RBE117-12020W17 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	8	8 ✓	0	0	0
5	RBE117-12020W18 Rev. ✓	RBE117-12020W18 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	4	4 ✓	0	0	0
6	RBT18700A-2 Rev. ✓	RBT18700A-2 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1	OXIDE-BLACK CH	12	12 ✓	0	0	0
7	RBST2812-P-11 Rev. ✓	RBST2812-P-11 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	11	11 ✓	0	0	0
8	RBST2812-P-9 Rev. ✓	RBST2812-P-9 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0
9	RBST2812-P-15 Rev. ✓	RBST2812-P-15 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0

DAS
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9-88



Certificat de Conformité / Certificate of Compliance

(014102-1)

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 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014102 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.					
09-Nov-2018		Aman				041549					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)			CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
10	RBEM652V3002101-M-27 Rev. ✓	RBEM652V3002101-M-27 BLACK OXIDE FINISH MIL-C-13924C CLASS 1			OXIDE-BLACK CH	13	13 ✓	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

